

Date: Thursday, 7/19/2007 2:25:32 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 WEB
Job Number	: 33657		
Estimate Number	: 10466		
P.O. Number	:	Part Number	: D33891
This Issue	: 7/19/2007 S.O. No. :	Drawing Number	: D3389 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 32629	Material	:
Written By	:	Due Date	: 7/26/2007 Qty: 4 Um: Each
Checked & Approved By	: <u>07.07.19</u>		
Comment	: Est Rev: A 05.08.31 New issue KJ/JLM		
	: Est Rev: B 06-02-08 As per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -1' Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Ext'n -1' Beam Web 4"

Pick:

Qty	Part Number
1	D2500-3-100

Description	Batch
Web Extrusion	B-31223

07/07/07/ANM

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
 1-Cut to length as per Dwg D3389

2-Drill pilot holes using DT8785 as per Dwg D3389

3-Open 1X .257" Dia Hole

4-Open Remaining holes to finish size as per Dwg D3389

5-Deburr

07/08/07 ANM DP

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Er 07/08/08 (x4)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07/08/10 ANM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:25:32 PM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 WEB

Job Number: 33657

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



pm 07-08-13 (4)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

L.G. AWM 07/08/14

(4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-08-14

Job Completion



07/08/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

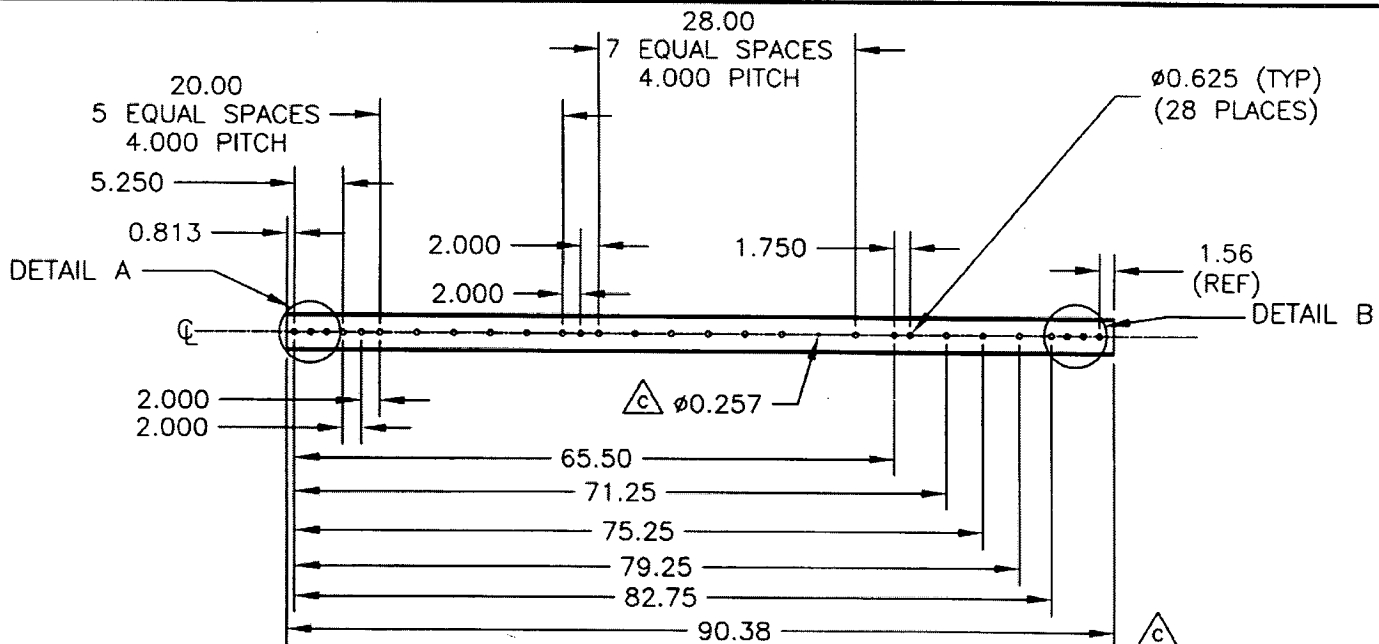
NOTE: Date & initial all entries



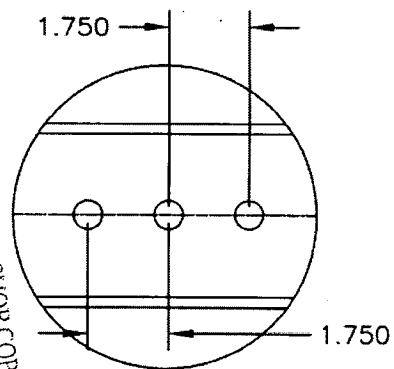
RELEASE

06.01.23

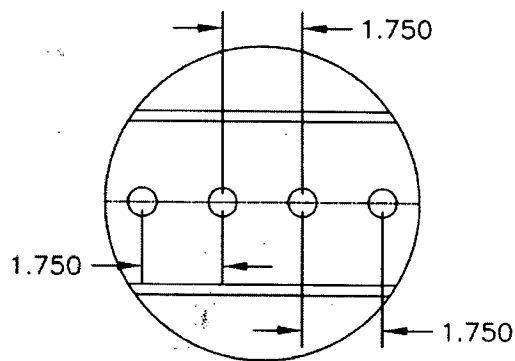
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	06.01.23	TITLE	412 WEB	REV. C
A	05.02.07	NEW ISSUE		
B	05.06.13	UPDATE DIMENSIONING		
C	06.01.23	DECREASE OVERALL LENGTH, MODIFY HOLE		



D3389-1 DRILLING DETAIL



DETAIL A
(SCALE 1:4)



DETAIL B
(SCALE 1:4)

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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33657

